

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013757**Date Inspected:** 03-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Caltrans QA inspection Mr. Wai Pau witnessed three welder qualification tests at OBG bay #14. The welder qualification test utilizing the SMAW process was conducted by Mr. Xiao Di (ID 203204), Mr. Wang Zhong Hua (ID 053753) and Mr. Wang Zhong Bui (ID 216086) performed in fillet weld over head position (4F). The material used for the welder qualification test specimens was reported by ZPMC QC Mr. Li Yan Hua (ID 07120701) as ASTM a 709M-345 plate with T-joint design (AWS section 5 figure 5.21). The proper filler metal used in the test for SMAW is E7018 with 4mm diameter electrode. The SMAW welding parameters used for the welder qualification tests were conducted in accordance with WPS No. WPS-B-P-2114. The three welder qualification tests were monitored and recorded CWI Mr. Li Yan Hua, aslo was observed by Caltrans QA inspector . The three welder qualification tests were appeared to be in general compliance with requirements of AWS D1.5 2002 section 5. A Caltrans Lot# B240-013-10, B240-014-10 and B240-015-10 were assigned on three welder qualification tests for tracking propose.

**CLOSING STATEMENT**

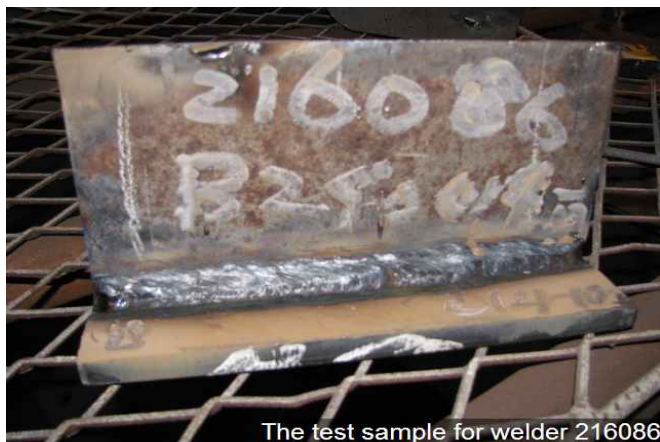
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## WELDING INSPECTION REPORT

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The test sample for welder 216086



The test sample for welder 053753



The test sample for welder 203204

### Summary of Conversations:

As notes within report above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Pau, Wai          | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Clifford, William | QA Reviewer                 |

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